

DN

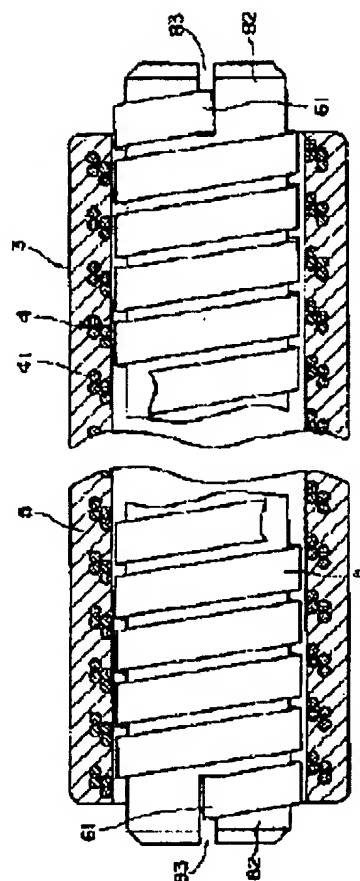
**METHOD OF MANUFACTURING FLEXIBLE TUBE FOR ENDOSCOPE**

**Patent number:** JP2002000551  
**Publication date:** 2002-01-08  
**Inventor:** IKEDA KUNITOSHI  
**Applicant:** ASAHI OPTICAL CO LTD  
**Classification:**  
- international: **A61B1/00; F16L11/04; F16L11/14; G02B23/24; G02B23/26; A61B1/00; F16L11/00; F16L11/04; G02B23/24; G02B23/26; (IPC1-7): A61B1/00; F16L11/04; F16L11/14; G02B23/24; G02B23/26**  
- european:  
**Application number:** JP20000181815 20000616  
**Priority number(s):** JP20000181815 20000616

Report a data error here

**Abstract of JP2002000551**

**PROBLEM TO BE SOLVED:** To provide a method by which a flexible tube for endoscope for which brazing and soldering can be used at the time of fixing a spiral tube to a braided body even when heat treatment is performed on the jacket of the tube and in which the spiral tube and braided body are coupled with the jacket with strong coupling forces (adhesion) can be manufactured. **SOLUTION:** This method includes a step of manufacturing a tube member 3 by putting the jacket 5 on a netted pipe 4 so as to cover at least part of the tube 4, a step of passing a core material 82 through the spiral tube 6 having an outside diameter  $D$  larger than the inside diameter ( $d$ ) of the tube member 3 in a natural state and temporarily fixing the core material 82 by reducing the diameter of the tube 6 so that the reduced outside diameter  $D'$  of the tube 6 may become  $D' < d$ , and a step of passing the spiral tube 6 temporarily fixed to the core material 82 through the tube member 3 and pulling out the core material 82 by releasing the material 82 from the temporarily fixed state. The method also includes a step of brazing and soldering the spiral tube 6 to the netted tube 4 at both ends of the tube 6 or their vicinities. The jacket 5 put on the netted tube 4 is heat-treated before the brazing and soldering step.



Data supplied from the esp@cenet database - Worldwide